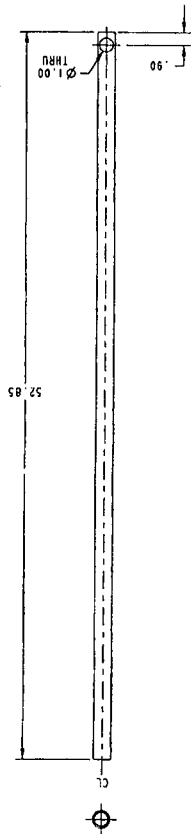


DART AEROSPACE LTD		Work Order:	39952
Description: WATER NOSE		Part Number:	D67-43001-
Dwg: D67-43001	SHEET 23	Qty:	247
			Page 1 of 1

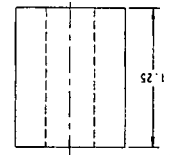
Step	Location	Procedure	By	Date
1	DC	Issue Traveller		
2	GA	PICK 1.25" OD x 0.025" WALL 6061-T6 WW-T-3016 AL TUBING CUT TO 52.85" LONG M18141=1	1/4	08.06.27
3	GA	DRILL Ø100" HOLE A) PER DWG. M18147=1	1/4	08.01.015
4	GA	PICK D67-43001-249 (1) M18147	1/4	08.01.085
5	LVA	INSERT D67-43001-249 INTO D67-43001-242 TUBING AND WELD A) PER DWG.	1/4	08.01.085
6A	GA	GRIND AND DEBUR FLASK TO CIRCUMFERENCE OF TUBING.	SAD	08.07.15
7	GA	IDENTIFY PART A) D67-43001-247		
6B	QCS	Inspect level		
PRELIMINARY ISSUE				

Rev	Date	Change	Revised By	Appro
		New issue	1/4	1/4

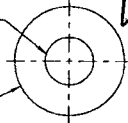
① -247 INNER TUBE  
MATERIAL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6  
SCALE: 0.250



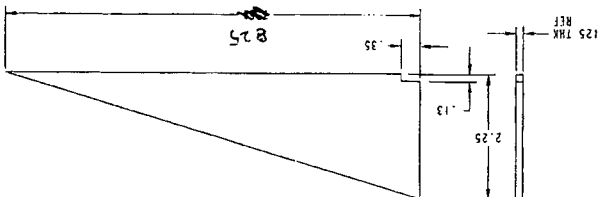
① -249 INNER TUBE BUSHING  
MATERIAL: 1.00 RND, 6061-T6, 00-A-200/8  
SCALE: 2.000



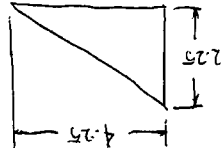
①  
Ø1.00 REF  
Ø.50/CL  
PILOT DRILL FOR HELICAL INSERT  
FOR INSERT SIZE AND SPEC.  
TAP FOR 4/16-20 UNC  
HELICAL INSERT.



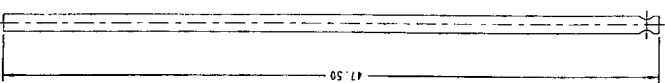
① -253 GUSSET  
MATERIAL: .125 THK, 6061-T6, 00-A-250/11  
SCALE: 1.000



① -254 GUSSET  
MATERIAL: .125 THK, 6061-T6, 00-A-250/11



① -257 INNER TUBE  
MATERIAL: 1.25 OD X .125 WALL, 6061-T6, WW-T-700/6  
SCALE: 0.250



RELEASED  
JUL 26 1962

PREMIER AVIATION, INC.  
2000 AVIATION PARKWAY, GRAND PRINCE, TEXAS 75050  
DLOSUV8 B67-43001  
SCALE: 1.000

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 21/07/2008 11:43:32 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER TUBE

Job Number: 40689

Part Number: PB6743001247

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *LVA*

*Ph 08-07-28 5*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/07/29*

Job Completion



*mf 08-07-28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 21/07/2008 11:43:32 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	INNER TUBE
<b>Job Number</b> :	40689		
<b>Estimate Number</b> :	13429		
<b>P.O. Number</b> :		<b>Part Number</b> :	PB6743001247
<b>This Issue</b> :	21/07/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	B6743001 P.23
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :		<b>Drawing Revision</b> :	B1
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	01/08/2008
<b>Written By</b> :		<b>Qty:</b>	5
<b>Checked &amp; Approved By</b> :	<u>JL 08.7.21</u>	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:A 08-06-26 new issue DD verified by:ec		

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T1250W125

ALUM. RD TUBING 1.250 x.125W



Comment: Qty.: 4.6244 f(s)/Unit Total : 23.1221 f(s)

ALUM. TUBING 1.250x.125W

batch: M18641=4 M18147=1

JL 08-06-27 5

2.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

2- deburr

JL 08-06-27 5

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-07-08 (5)

4.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

1- drill hole as per dwg

2- deburr

JL 08-07-08 5

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-07-08 (5)